

WHAT IS CLAIMED IS:

1. Directly pressed cutting insert for chip removing machining formed by a pressing force acting in a pressing direction, the insert comprising a top surface, a bottom support surface, and edge surfaces interconnecting the top and support surfaces; said top surface comprising a rake face; a cutting corner being formed in an area of an intersection of two of the edge surfaces; the cutting corner comprising a first cutting edge; one of said edge surfaces comprising a first clearance surface having a first clearance angle, and a second clearance surface having a second clearance angle greater than the first clearance angle; both of the first and second clearance surfaces connecting to the same first cutting edge; the cutting insert having a negative basic shape, wherein a major part of at least some of the edge surfaces is parallel to the pressing direction.
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2. Cutting insert according to claim 1 wherein the first clearance surface is parallel to the pressing direction.
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3. Cutting insert according to claim 1 wherein the first clearance surface has an extension to a point on the first cutting edge.
4. Cutting insert according to claim 1 wherein the first clearance surface connects to a chip breaker surface.
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5. Cutting insert according to claim 4, wherein a lower limiting line of the first clearance surface is arranged at a distance from the chip breaker, said distance substantially increasing from a chip forming end area in the direction of an adjacent chip forming end area.
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6. Cutting insert according to claim 1 wherein the first cutting edge connects to a convex second cutting edge on the cutting corner.

5 7. Cutting insert according to claim 1 wherein the first cutting edge is straight.

10 8. Cutting insert according to any claim 1 wherein the cutting insert comprises a groove-turning cutting insert or slot turning cutting insert.

15 9. Cutting insert according to claim 1 wherein the cutting insert comprises a triangular cutting insert.

20 10. Cutting insert according to claim 1 wherein the first clearance surface is parallel to the pressing direction and has an extension to a point on the first cutting edge, the first clearance surface connecting to a chip breaker surface, a lower limiting line of the first clearance surface arranged at a distance from the chip breaker, said distance substantially increasing from a chip forming end area in the direction of an adjacent chip forming end area, the first cutting edge connecting a convex second cutting edge on the cutting corner.